

Work Order ID 55169

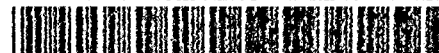
January 8, 2010 10:14:31 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 08/01/2010 Start Qty: 1.00

Required Date: 26/01/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 10-1-08 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

10-1-26

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

AWM / H 01/1/18

55169

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55169

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Item ID: D205-634-041

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 08/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 26/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

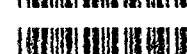
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

①

25 10/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 08/01/2010 Start Qty: 100

Cust Item ID:

Required Date: 26/01/2010 Req'd Qty: 100

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R Aluminum Rod

M112860

BE 10/01/19

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

M112860

BE 10/01/19

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for all cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Towing using DT8091, open to .640" and Debur

AWM 10-1-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 08/01/2010 Start Qty: 1.00

Customer ID:

Required Date: 25/01/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



⇒ 81061120

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



⇒ 81061120

QC

Memo

0.00

Quality Control

(X)

170

Pressure Wash per QSI005 4.3

0.00



⇒ 81061121

HandFinish

Memo

0.00

Hand Finishing

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 55169

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

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Item Name: Replacement Skidtube

Start Date: 08/01/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 26/01/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00AM
320°F
11:30AM

0.00

74 10-01-20

(X1) 8

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BR 10-01-22

Q

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 08/01/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 26/01/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ Sikaflex-291

Sikaflex expire date:

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ Sikaflex-291

Sikaflex expire date:

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

Bl 10-06-22 B

M112900

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55169

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Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 08/01/2010 Start Qty: 1.00

Cust Item

Required Date: 26/01/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

27 8061122

40



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

0.00

Packaging



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: J

10/01/26

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27 MF 10-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

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Work Order ID: 55169



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev. 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. 06.02.28 Added paperwork EC
 IPP Rev. 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2580-1 DP		Manufactured	No			110	Each	11.0000	1.0000			



205 Skidtube bent detail

Warehouse	Loc Qty	Loc Code
<u>Location</u>		

Main Warehouse

LG	7	
54120	1	
54541	2	
54648	2	
54697	2	

ARM 10-1-18

Main Warehouse

ST	4	
54500	2	
54647	2	

D2576-3

Manufactured No

140 Each 151.0000 1.0000



Step (maching detail)

Warehouse	Loc Qty	Loc Code
<u>Location</u>		

Main Warehouse

ST	151	
43504	3	
46661	101	
52215	47	

1 BE 10/01/19

Picklist Print

January 8, 2010 10:14:36 AM

Work Order ID: 55169



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev: O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2579		Manufactured	No			140	Each	381.0000	20.0000			



Crossbolt Spacer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	259	
51525	4	
53780	3	
54543	38	
54642	214	
Main Warehouse		
ST	122	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	

20 SE 10/01/19

Picklist Print

January 8, 2010 10:14:36 AM

Work Order ID: 55169



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev: N 02-08-28 FP was QC5 in Step 27; Added QC5 to Step 30. KJ
 IPP Rev: O 02-07-28 Added paperwork EC
 IPP Rev: P 02-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2855		Manufactured	No			200	Each	159.0000	1.0000			



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6	159	
50513	1	
50770	1	
51539 ✓	42	
53791	115	

1 BL 10-01-22

AN3-5A Purchased No

200 Each 1,965.000 2.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1965	
100188	188	
105057 ✓	1777	

2 BL 10-01-22

Picklist Print

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 IPP Rev: O 06.02.28 Added paperwork EC
 IPP Rev: P 07.07.09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD10L		Purchased	No			200	Each	4,741.000	2.0000			



Washer

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	4741	
101291	16	
104885	16	
105793	105	
109632	170	
110985 ✓	4434	

2 bl 10-01-22

ALS7-1032-130 Purchased No

200 Each 1,494.000 50.0000



Insert

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1494	
105855	16	
108606	52	
111529	152	
111779	313	
112772	11	
113238	950	

50 bl 10-01-22

ALS4-1032-130 110511

Picklist Print

January 8, 2010 10:14:36 AM

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3C4A		Purchased	No			200	Each	1,181.000	50.0000			



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	1181	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226	586	
113422 ✓	500	

50 Bk 10-a-22

AN960C10L Purchased No

200 Each 388.0000 50.0000



washer

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG	113288	100
103585		100

50 Bk 10-01-22

Main Warehouse

ST		288
112116		128
112612		160

NAS 1149C0332R.

Picklist Print

January 8, 2010 10:14:36 AM

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Parent Item Name: Replacement Skidtube

Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev: O 06.03.28 Added paperwork EC
 IPP Rev:P 07.07.09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3566-13		Manufactured	No			200	Each	93.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 91

51606 ✓ 9

53461 82

Main Warehouse

ST 2

45717 1

50265 1

D3566-5 Manufactured No

200 Each 14.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 55020 10

53804 10

Main Warehouse

ST 4

36113 1

46186 1

47318 1

51260 1

1 BK 10-a-22

1 BK 10-01-22

Picklist Print

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Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev: O 06.12.28 Added paperwork EC
 IPP Rev: P 07.07.09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Units of	Qty on	Remaining	Qty	Date	Status
D3566-1		Manufactured	No			200	Each	25.0000	2.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 55011

20

52512

3

54480

17

Main Warehouse

ST

5

46349

1

51218

1

51259

3

D3564-11

Manufactured No

200

Each

15.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

13

52125

13

Main Warehouse

ST

2

45823

1

50112

1

2 BK 10-01-22

1 BK 10-01-22

Picklist Print

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Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30. KJ
 IPP Rev: O 06.02.28 Added paperwork EC
 IPP Rev:P 07.07.09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3564-13		Manufactured	No			200	Each	33.0000	1.0000			



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

21

51611 ✓

21

Main Warehouse

ST

12

45409

2

46495

10

D3564-9

Manufactured No

200

Each

12.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

10

53806 ✓

10

Main Warehouse

ST

2

44659

1

45825

1

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Shop Packet Print

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Picklist Print

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Start Date: 08/01/2010

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 IPP Rev: O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3564-5		Manufactured	No			200	Each	13.0000	1.0000			



Wearshoe



Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 55333

2

34806

2

Main Warehouse

FP19

9

51925

1

53805

8

Main Warehouse

ST

2

45824

1

47433

1

D2594-3

Manufactured No

200

Each

346.0000

16.0000



O-Ring, 205 Skidtube



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

27

51613

27

Main Warehouse

ST

319

52562 ✓

319

1 BR 10-01-22

16 BR 10-01-22

January 8, 2010 10:14:36 AM

Shop Packet Print

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Picklist Print

January 8, 2010 10:14:36 AM

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Start Date: 08/01/2010

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Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2594-1		Manufactured	No			200	Each	234.0000	16.0000			



Plug, 205 Skidtube



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	106	
54008	1	
54643 ✓	105	
Main Warehouse		
ST	128	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	6	
55002		

15 bl 10-01-22

1 bl 10-01-22



DESIGN #	DRAWN BY BH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07 06 28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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NO. 55169
BS10-1-08

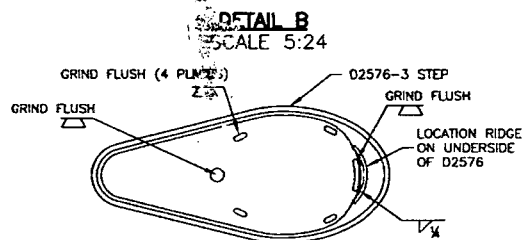
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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SCALE 5:24

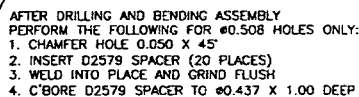


SCALE 5:24

SCALE 5:24



SECTION D-D
SCALE 5:24



37.50
DISTANCE TO AFT END
OF D2596 WEB
3 7
REFER TO DETAIL A
1.750 1.750
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

[illegible]

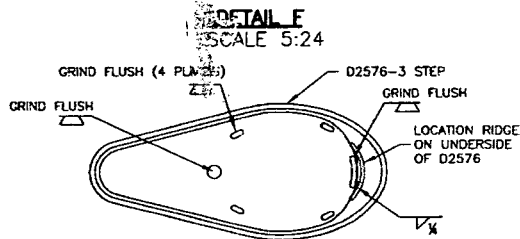
INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DRAWN BY	<i>PH</i>
APPROVED	<i>H</i>

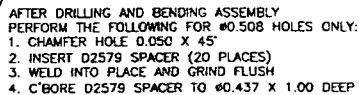
DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

SCALE 5:24



RELEASED
07 Dec 1964

SCALE 5:24

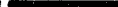


FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
* IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

[illegible]

Figure 1: Elevation view of the bridge deck showing dimensions and callouts. The diagram includes a cross-section of the bridge deck with various dimensions and callouts. Key dimensions include: 5.985, 5.338 (REF), 51.340, 39.580, 5.915, 3.630 (REF), 0.508 (8 PLACES), 20.0, 0.640, 1.4, 1.0, 13.4, 32.0 ± 1.0, and 11. Callouts include '4' and '4'.

[illegible]

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	CHECKED <i>H</i>	APPROVED <i>H</i>		DRAWING NO. D2580
	DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24

NO. 221

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berclay Elliott
Job number: 542020
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 09.12.17

Welder [Signature] Date of Test Coupon 09.12.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld